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IS 3344 (1965) : D.W Tarpauline Jute Bags Packing (Mint)
Coins [TXD 3: Jute and Jute Products]

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Indian Standard

SPECIFICATION FOR
D.W. TARPAULING JUTE BAGS FOR
PACKING (MINT) COINS

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Indian Standard

SPECIFICATION FOR
D.W. TARPAULING JUTE BAGS FOR
PACKING (MINT) COINS

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Indian Standard

SPECIFICATION FOR

D.W. TARPAULING JUTE BAGS FOR PACKING (MINT) COINS

0. FOREWORD

0.1 This Indian Standard was adopted by the Indian Standards Institution on 4 October 1965, after the draft finalized by the Jute and Jute Products Sectional Committee had been approved by the Textile Division Council.

0.2 During normal course of transit and storage, jute bags filled with coins undergo rough handling. It is, therefore, a matter of great importance to lay down the requirements of jute bags which would satisfactorily withstand such normal usages. Directorate General of Supplies and Disposals, who are major purchasers of jute bags for packing coins, proposed this subject for formulation of Indian Standard specification. It is expected that jute bags conforming to this specification would form a satisfactory packing material for coins.

0.3 All quantities and dimensions in this standard have been expressed in the metric system. However, the foot-pound system values to which the industry is accustomed, have also been given, wherever necessary, within brackets.

0.4 For the purpose of deciding whether a particular requirement of this standard is complied with, the final values, observed or calculated, expressing the results of tests, shall be rounded off in accordance with IS : 2-1960*. The number of significant places retained in the rounded off values should be the same as that of the specified values in this standard.

1. SCOPE

1.1 This standard prescribes the constructional details and other particulars of hemmed D.W. (double warp) tarpauling jute bags for packing (mint) coins of dimensions 47×35 cm (or $18\frac{1}{2} \times 13\frac{3}{4}$ in) and 42×28 cm (or $16\frac{1}{2} \times 11$ in).

*Rules for rounding off numerical values (*revised*).

2. TERMINOLOGY

2.0 For the purpose of this standard, the following definitions shall apply.

2.1 Lot — All bales of jute bags purporting to be of specified dimensions and quality, containing one definite number of bags, delivered to one buyer against one despatch note.

2.2 Bale — A rectangular or square pressed rigid package containing jute bags and covered with bale covering with outer layer stitched, and bound by metal hoops in conformity with IS : 2873-1969*.

2.3 Contract Weight (Bale) — The weight as obtained by multiplying the nominal weight of a bag and specified number of bags per bale (*see Note 1 in Table 2*).

2.4 Corrected Net Weight (Bale) — The weight obtained by adjusting the actual net weight on the basis of actual regain to the contract regain (*see Note 2 in Table 2*).

2.5 Contract Regain — The contract moisture regain is the percentage regain on the basis of which the corrected net weight is calculated.

2.6 Ends — The warp threads of a fabric.

2.7 Porter — The value obtained by counting, in bags made of jute tarpauling as marketed, the number of warp threads per full gauge length of 47 mm (or 37/20 in) and dividing it by the number of warp threads per split, which here is 4.

NOTE — This definition of porter, based on the Indian practice refers to the finished fabric, and has to be distinguished from the Dundee practice, according to which porter is evaluated in terms of loom reed used in weaving the cloth.

2.8 Pick (or Shots) — The weft or filling threads of a fabric.

NOTE — Shots per inch = picks per decimetre $\times 0.254$.

2.9 Joined Bag — A bag made out of two pieces of jute sacking.

3. GENERAL REQUIREMENTS

3.1 Tarpauling — The bags shall be made from single pieces (joined bags being not permitted) of double warp, plain jute tarpauling of uniform construction and with the warp running along the length of the bags. The weight per square metre of the tarpauling used in the fabrication of the bags shall be 550 g.

3.2 Seam — The sides of the bags shall be sewn with overhead stitches using two strands of three-ply jute twine of 340 tex $\times 3$ (or 10 grist $\times 3$).

*Specification for packaging of jute products in bales.

The sewing shall be done through two thicknesses of cloth if both the edges to be sewn are selvedges, through three thicknesses of cloth if one edge is a selvedge and the other raw edge, and through four thicknesses of cloth if both the edges are raw edges. The stitching shall be of even tension throughout with all the loose ends securely fastened. The number of stitches per 10 cm at the sides shall be between 14 and 16. There shall be no seam at the bottom of the bag.

3.3 Hemming at the Mouth — At the mouth of the bags, the raw edges of cloth shall be turned over first to a depth of about 1 cm and then to a depth of about 2 cm and the three layers of cloth thus formed shall be hemmed with cotton yarn of Nf 14/3 (or 36 tex \times 3) (*see Note*). The number of stitches per 10 cm in the hem shall be between 24 and 26.

NOTE — French count (Nf) = number of 1 000 m hanks per 0.5 kg.

4. SPECIFIC REQUIREMENTS

4.1 The tarpauling and the bags made out of it shall conform to the requirements laid down in Table 1 (*see P 6*).

4.2 The bales containing the bags shall conform to the provisions laid down in Table 2 (*see P 7*).

4.3 Contract Regain — The contract moisture regain shall be 20 percent.

5. PACKING AND MARKING

5.1 The bags shall be packed in bales as laid down in IS : 2873-1969* or as specified in an agreement between the buyer and the seller.

5.2 Marking — The bales shall be marked as laid down in IS : 2873-1969*. Additional markings shall be made as stipulated by the buyer or required by the regulation or laws in force.

5.2.1 The bales may also be marked with the ISI Certification Mark.

NOTE — The use of the ISI Certification Mark is governed by the provisions of the Indian Standards Institution (Certification Marks) Act and the Rules and Regulations made thereunder. The ISI Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well-defined system of inspection, testing and quality control which is devised and supervised by ISI and operated by the producer. ISI marked products are also continuously checked by ISI for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the ISI Certification Mark may be granted to manufacturers or processors, may be obtained from the Indian Standards Institution.

*Specification for packaging of jute products in bales.

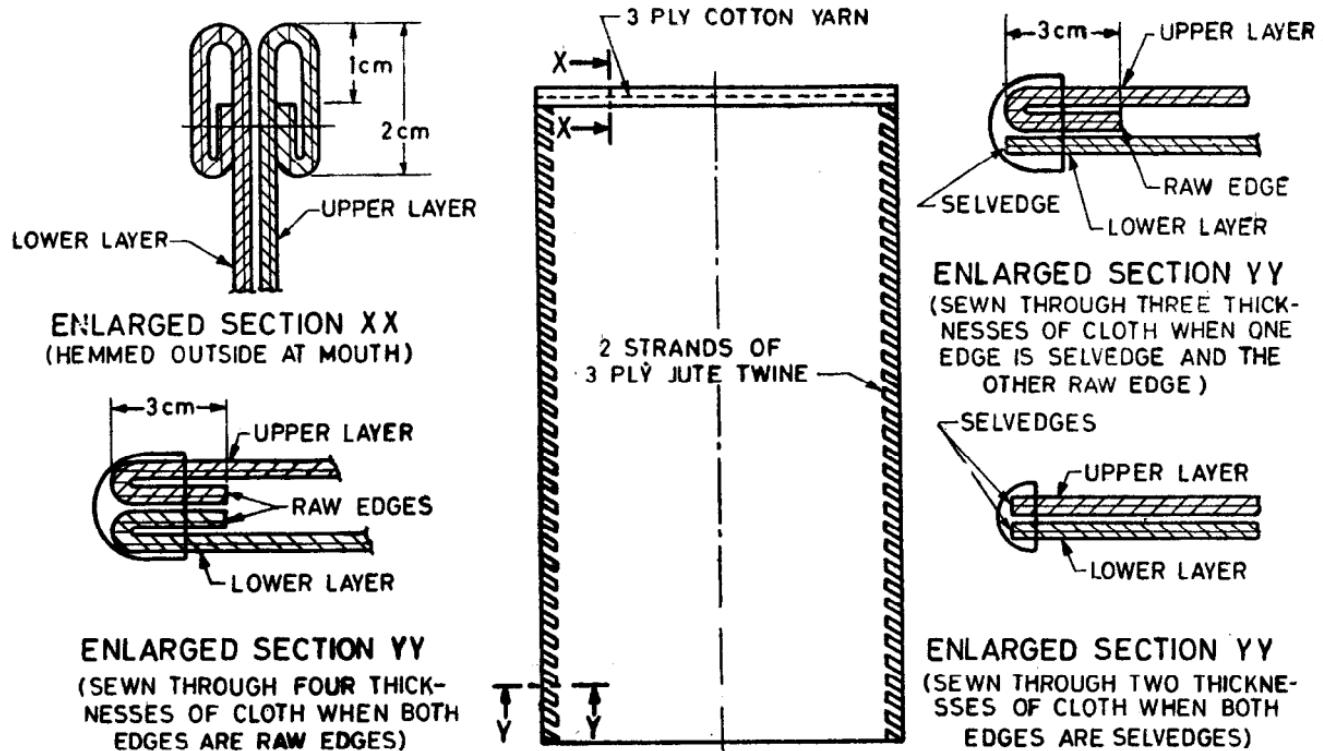


FIG. 1. D.W. TARPAILING JUTE BAG

TABLE 1 PARTICULARS OF TARPAULING AND BAGS
(Clause 4.1)

| SL No. | CHARACTERISTIC | REQUIREMENT | TOLERANCE | METHOD OF TEST (REF TO CLAUSE No. OF APPENDIX B) |
|-----------|---|--|----------------------------------|---|
| i) | Dimensions of a bag: | | | |
| | Size 1 { a) Outside length b) Outside width | 47 cm (or 18½ in) 35 cm (or 13¾ in) | +3 cm —0 cm +3 cm —0 cm | |
| ii) | Size 2 { a) Outside length b) Outside width | 42 cm (or 16½ in) 28 cm (or 11 in) | +3 cm —0 cm +3 cm —0 cm | B-5 |
| | Weight per bag: | | | |
| Size 1 | | 210 g | +20g —15g | |
| Size 2 | | 155 g | +15g —10g | B-3 |
| iii) | Ends per dm (or porter) | 86(10) | ±5 | B-6 |
| iv) | Picks per dm (or shots per in) | 48(12) | ±3 | B-6 |
| v) | Breaking load of tarpauling Strip method (100 × 200 mm): | | | B-7 |
| | Warpway | 170 kg (or 375 lb) | — | — |
| | Weftway | 180 kg (or 397 lb) | — | — |
| vi) | Breaking load of seam (Strip size 50 × 200 mm) | 67 kg (or 148 lb) | — | B-8 |

NOTE 1 — For dimensions of bag with different specified values, such as agreed to between the buyer and the seller, the same tolerance of $+3$ cm shall apply.

NOTE 2 — Weight per bag specified above applies to bags having selvedges on one side and raw edges on the other. Weight of bags of other dimensions and type shall be proportional to the standard bag (210 g, 47 × 35 cm or 155 g, 42 × 28 cm) and calculated on the basis of the area of the tarpauling including the hem and seamed portion, with tolerance of $+10$ percent on bag weight.

TABLE 2 REQUIREMENTS OF PACKED BALES

(Clause 4.2)

| SL No. | CHARACTERISTIC | REQUIREMENT | METHOD OF TEST (REF TO CLAUSE NO. OF APPENDIX B) |
|-----------|---|-----------------------------------|--|
| i) | Total number of bags per bale | Not less than the declared number | B-4 |
| ii) | Contract weight of a bale | <i>See Note 1</i> | — |
| iii) | Corrected net weight of a bale | Not less than contract weight | B-1 |
| iv) | Moisture regain | 22 percent, <i>Max</i> | B-2 |
| v) | Oil content on dry deoiled material basis | 8 percent, <i>Max</i> | B-9 |

NOTE 1 — Contract weight of a bale is calculated as follows:

$$\text{Contract weight of a bale} = \text{nominal weight of a bag} \times \text{specified number of bags per bale}$$

NOTE 2 — Corrected net weight of a bale is calculated as follows:

$$\text{Corrected net weight of a bale} = \frac{\text{Net weight} + (\text{100} + \text{contract regain percent})}{\text{100} + \text{average moisture regain percent}}$$

NOTE 3 — The specified oil content value of 8 percent corresponds to about 7 percent when determined by dry deoiled material plus 20 percent regain basis.

6. SAMPLING AND INSPECTION

6.1 Unless otherwise agreed to between the buyer and the seller, the procedure for sampling shall be as given in Appendix A and the procedure for testing and inspection as given in Appendix B.

7. CRITERIA FOR CONFORMITY

7.1 The lot shall be considered as conforming to the requirements of the standard, if the following conditions are satisfied:

- The total of the corrected net weight of the bales under test is not less than the total contract weight of the bales (*see* Table 2).
- The number of bags in each bale under test is not less than the number marked on the bale (*see* Table 2).
- The average moisture regain percent of the bags under test is not more than the specified percentage (*see* Table 2).
- The average oil content of the bags under test is not more than the specified percentage (*see* Table 2).

- e) The dimensions of at least 90 percent of the bags under test are in accordance with the requirements specified (*see* Table 1). In the remaining bags, no bag shall have dimensions less than 1.5 cm below the specified values.
- f) The weight of at least 90 percent of the bags under test is in accordance with the requirements specified (*see* Table 1). In the remaining bags, no bag shall have weight less than 10 percent below the specified value.
- g) The average ends per decimetre of the bags under test is in accordance with the requirement specified (*see* Table 1).
- h) The average picks per decimetre of the bags under test is in accordance with the requirement specified (*see* Table 1).
- j) The average breaking load values of the bags under test for both warp and weft directions are not less than the requirements specified (*see* Table 1).
- k) The average breaking load of seam of the bags under test is not less than the requirement specified (*see* Table 1).

A P P E N D I X A

(*Clause 6.1*)

SAMPLING FOR D.W. TARPAULING JUTE BAGS

A-0. SAMPLING PROCEDURE

A-0.1 The following minimum number of bales and bags shall be taken at random from the lot and subjected to corresponding tests (*see* Appendix B).

A-1. GROSS WEIGHT

A-1.1 For evaluating the gross weight of bales, 10 percent of bales, selected from the lot, shall constitute the **test sample**.

A-2. REQUIREMENTS OTHER THAN GROSS WEIGHT

A-2.1 For assessing the conformity to the requirements, other than gross

weight of bales, the number of bales to be selected from the lot shall be in accordance with the following table:

| <i>No. of Bales in the Lot</i> | <i>No. of Bales to be Drawn and Opened for Inspection</i> |
|--------------------------------|---|
| (1) | (2) |
| Up to 10 | 1 |
| 11 „ 20 | 2 |
| 21 „ 100 | 3 |
| 101 „ 150 | 4 |
| 151 „ 200 | 5 |
| 201 „ 250 | 6 |
| 251 „ 300 | 7 |
| 301 „ 350 | 8 |
| 351 „ 400 | 9 |
| 401 „ 500 | 10 |

A-2.2 From the bales selected as in **A-2.1**, the **test sample** shall be drawn as follows:

| <i>Sl No.</i> | <i>Tests</i> | <i>Test Sample</i> |
|---------------|---|---|
| i) | Tare weight (of baling hoops and all other packing materials) | The bales selected as in A-2.1 |
| ii) | Total number of bags per bale | Two bundles of bags from each bale selected as in A-2.1 |
| iii) | Moisture regain, percent | |
| iv) | Length and width | 10 bags from each bale selected as in A-2.1 |
| v) | Ends and picks | |
| vi) | Weight per bag | 10 percent of bags from each bale selected as in A-2.1 |
| vii) | Breaking load — sacking | |
| viii) | Breaking load — seam | One bag from each bale selected as in A-2.1 subject to a minimum of three bags |
| ix) | Oil content, percent | |

APPENDIX B

(Clauses 6.1 and A-0.1)

B-0. TESTING AND INSPECTION PROCEDURE

B-0.1 Testing and inspection of the lot as laid down below shall be carried out on the samples drawn in accordance with Appendix A.

B-1. WEIGHT OF BALES

B-1.1 Determine the total gross weight of the bales in the test sample (**A-1**) from the gross weight of each bale taken up to nearest kilogram (W_g).

B-1.2 Remove the baling hoops and all other packing materials of the bales and weigh them together up to nearest kilogram. Calculate the average tare weight of bale and multiply by the number of bales weighed (W_t).

B-1.3 The total net weight of bales under test, $W_n = (W_g - W_t)$.

B-1.4 Determine the total corrected net weight (W) of bales under test by the following formula:

$$W = \frac{W_n \times (100 + \text{contract regain percent})}{100 + \text{average moisture regain percent of bales}} \quad (\text{B-2})$$

B-2. MOISTURE REGAIN

B-2.1 Determine the moisture regain in each bag (**A-2.2**) on opening the bales (**A-2.1**) by the use of a suitable moisture meter.

NOTE — IJIRA (Indian jute Industries' Research Association) moisture meter* may be used for the purpose. This meter works on the principle of measuring the electrical resistance which changes with moisture content of the material. The specimen (jute products) is placed under the electrode gun having two poles of specially designed spring-loaded electrodes. The small amount of current passing through the electrodes is amplified and recorded on the meter calibrated against the actual moisture regain, based on oven-dry method, of the material. A separate chart calibrating the actual moisture regain, based on oven-dry method, of the material may also be used. The instrument shall be operated according to the manufacturer's instructions.

B-3. WEIGHT PER BAG

B-3.1 Weigh each bag (**A-2.2**) to the nearest 5 g after tests for **B-1** and **B-2**.

B-4. NUMBER OF BAGS PER BALE

B-4.1 Count the number of bundles of bags in each bale (**A-2.1**) and number of bags in each bundle (**A-2.2**). From the above, determine the total number of bags in each bale under test.

NOTE — There should be no joined bags in each bale.

*Mention of the name of the specific instrument is not intended to promote or give preference to the use of that instrument over others not mentioned.

B-5. LENGTH AND WIDTH

B-5.1 Lay each bag (**A-2.2**) flat on a table free from creases and wrinkles and measure the outside length and outside width about the centre to the nearest 0.5 cm.

B-6. ENDS AND PICKS

B-6.1 Count the ends and picks from each bag (**A-2.2**) in one and two places respectively with a suitable gauge measuring 5 cm. Determine the average ends and picks per decimetre of the bags under test in accordance with 7 of IS : 1963-1961*.

B-7. BREAKING LOAD OF SACKING

B-7.1 Test from each bag (**A-2.2**) two warpway and two weftway specimens for breaking load with 100 mm wide ravelled strips and 200 mm between grips of a strength tester having a constant-rate-of-traverse of 460 mm (or 18 in) per minute according to **9.1** of IS : 1969-1961†.

NOTE — Tests for breaking load of sacking may be carried out in the prevailing atmospheric conditions with relative humidity between 40 and 90 percent.

B-8. BREAKING LOAD OF SEAM

B-8.1 Test one test specimen for breaking load of seam from each side of the bags (**A-2.2**) taking 200 mm between grips with the seam near about the centre, using constant-rate-of-traverse machine operating at 460 mm (or 18 in) per minute.

Prepare the test specimens in the form of a double 'T' with 100 mm of seam and 50 mm width of fabric as shown in Fig. 2.

NOTE — Tests for breaking load of seam may be carried out in the prevailing atmospheric conditions with relative humidity between 40 and 90 percent.

B-9. OIL CONTENT

B-9.1 From each bag take one representative strip (**A-2.2**) and determine oil content on dry deoiled material basis by Soxhlet extraction using trichloroethylene as solvent, by the following formula:

$$\text{Oil content, percent, on dry deoiled material basis} = \frac{W_2}{W_d} \times 100$$

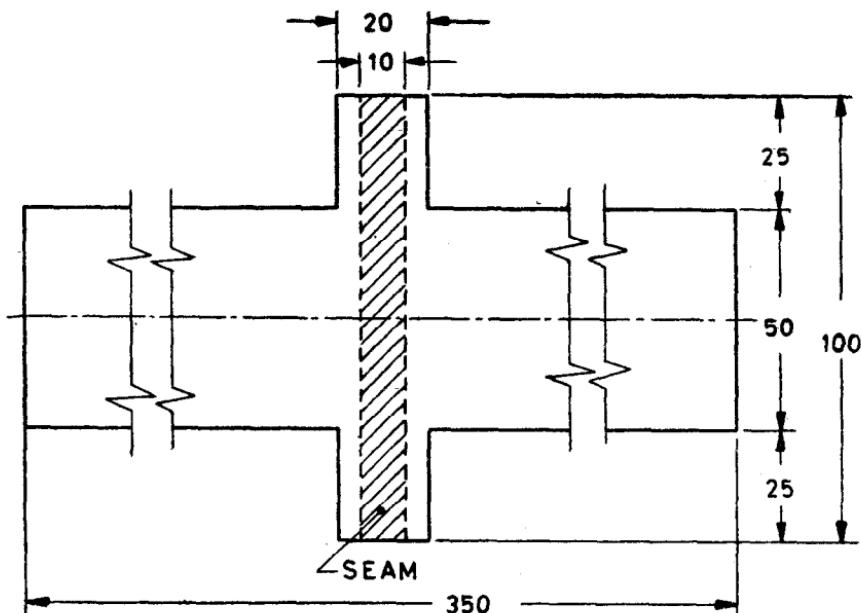
where

W_o = weight, in g, of the extracted material (including natural fat and wax and batching oil); and

W_d = oven-dry weight, in g, of the fabric after extraction.

*Method for determination of ends and picks per unit length in woven fabrics. (Since revised).

†Method for determination of breaking load and elongation at break of woven fabric (by constant-rate-of-traverse machine). (Since revised).



All dimensions in millimetres.

FIG. 2 SIZE AND SHAPE OF TEST SPECIMEN FOR SEAM STRENGTH

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TO

IS:3344-1965 SPECIFICATION FOR D.W. TARPAULING
JUTE BAGS FOR PACKING (MINT) COINS

(This Amendment is being issued to make provision for stitching with herakle stitch in addition to overhead stitch and also to modify the number of stitches/dm to fall in line with other standards on jute bags).

(Pages 3 and 4, clause 3.2) - Substitute the following for the existing clause:

'3.2 Seam - The sides of the bags shall be sewn with overhead or herakle stitches using 2 strands of three-ply jute twine of 380 tex X 3 for overhead stitch and 300 tex X 3 for herakle stitch. The sewing shall be done through two thicknesses of cloth if both the edges to be sewn selvedges, through three thicknesses of cloth if one edge is a selvedge and the other raw edge, and through four thicknesses of cloth if both the edges are raw edges. The stitching shall be of even tension throughout with all the loose ends securely fastened. There shall be no seam at the bottom of the bag. The number of stitches per dm shall be between 9 to 11.'

(TDC 3)

AMENDMENT NO. 4 NOVEMBER 2005

TO

**IS 3344 : 1965 SPECIFICATION FOR D. W.
TARPAULING JUTE BAGS FOR PACKING (MINT) COINS**

(*Cover page, pages 1 and 2*) — Substitute ‘tarpaulin’ for ‘tarpauling’ and wherever it appears in the test.

(*Page 4, clause 3.2*) — Insert the following note at the end of the clause:

‘NOTE — The count of jute twine is given for guidance only.’

(*Page 4, clause 3.3, Note*) — Add the following in the existing note:

‘The count of yarn is given for guidance only.’

[*Page 7, Table 2, Sl No. (v), Under ‘Requirement’*] — Substitute ‘3’ for ‘8’.